

Work Order ID 74797

\*74797\*

Page 1

October 6, 2011 1:40:22 PM

Item ID: D119-646-241

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 10/06/11 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/10/06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3887	B
IIN-D119-646	B

100

0.00

\*100\*

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP 19119-646-241 CHG001

SCRAP

110

0.00

\*110\*

Skidtubes

Skidtubes

Memo

0.00

1- inspect Mat'L D2500-1-190 for damage

2- Remove 45.3125" from d2500-1-180, deburr ends.

3- Ensure squareness of ends and scribe batch#

DE 12/05/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Item ID: D119-646-241

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\*N9000040100\*

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Revision ID:

Stop \*NS2\*

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Start Date: 10/06/11 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Chemical Conversion Coat per QSI005 4.1	0.00							
*120*									
HandFinish	Memo	0.00							
Hand Finishing									
121	QC3- Inspect Part Finish	0.00							
*121*									
QC	Memo	0.00							
Quality Control									
122	QC5- Inspect part completeness to step on *W/O	0.00							
*122*									
QC	Memo	0.00							
Quality Control									

DC 12/05/16

1 0 BE12/05/16

1 0 BE12/05/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D119-646-241

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**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 10/06/11 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

**\*130\***

Skidtubes

Skidtubes

**Memo**

0.00

1-Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill

2-Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) \*\*\*DO NOT OPEN FWD Saddles Holes\*\*\*

3- Deburr, blow out chips from inside of tube.

4 -Bond web in place as per Dwg D3887 &amp; QSI 015.

A/RSikaflex-291 12/22/11

Sikaflex expire date: 13/01/04

Start: 8:05 Time: 12/05/16

Finish: \_\_\_\_\_ Time: \_\_\_\_\_

\*\*\*\*\* (Adhere for 12 hours) \*\*\*\*\*

DC 12/05/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Item ID: D119-646-241

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Replacement Skidtube STD w/ Training Wearplates

Stop

**\*NS2\***Start Date: 10/06/11 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

135

QC5- Inspect part completeness to step on W/O

0.00


**\*135\***

QC

Memo

0.00

Quality Control

 12-5-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 74797****\*74797\***

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Item ID: D119-646-241

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 10/06/11 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. - Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	------------------

140

0.00

**\*140\***

Skidtubes

Skidtubes

**Memo**

0.00

1- Bend FWD end of tube using bender 1 and bend prog. D3887.\*\*\*Must use bending aid DT9544, ensure proper positioning\*\*\*

2- Cut FWD end of tube as per dwg D3887.\*\*\*Verify measurment\*\*\*

3- Buff out marks left from bending

4- Drill FWD cap holes using DT8215. Open FWD &amp; AFT cap holes to 0.208"

5- Open FWD saddle holes to finished size as per dwg D3887

6- Drill FWD x-bolt spacer holes to finished size ( holes must be laid out manually.)

7- Drill Tow ring hole,holes must be laid out manually . Open to finished size.

8- Deburr and blow out chips from inside of tube.

12-6-19 PTO

W/O: 74797

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector
		<i>1 beam #459</i>					

Part No: D119-646-241 PAR #: \_\_\_\_\_ Fault Category: Kid tube NCR: ☒ Yes ☐ No DQA: 12/07/24 Date: 12/07/24  
 Resolution: \_\_\_\_\_ Disposition: Scrap QA: N/C Closed: 12/07/24 Date: 12/2/24

NCR: <u>12-11613</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>12-6-19</u>	<u>140</u>	<u>Tube broke while bending.</u>	<u>W</u>	<u>Scrap tube</u>	<u>CE</u>	<u>12-7-18</u>	<u>U</u>	<u>DAS</u>
		<u>RC, Process</u>	<u>12-07-18</u>	<u>NO replace.</u>	<u>CE</u>	<u>12-7-18</u>	<u>12-07-18</u>	<u>16</u>
				<u>Remove I-Beam +</u>				<u>9-89</u>
				<u>re-Stock</u>				<u>17/07/18</u>

NOTE: Date &amp; initial all entries

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Item ID: D119-646-241

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**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 10/06/11 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

160

0.00

**\*160\***

Skidtubes

Memo

0.00

Skidtubes

1- Countersink crossbolt spacer holes, and prepare tube for welding, deburr.

2-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/RAluminum Rod \_\_\_\_\_

3-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole.

4-Counterbore x-bolt spacer holes as per Dwg D3887.

5- Deburr and blow out chips from inside of tube

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*74797\***

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

Stop \*NS2\*

**Cust Item ID:**

**Customer:**

Run Start \*NR1\*

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

170	QC5- Inspect part completeness to step on W/O	0.00
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QC5- Inspect part completeness to step on W/O

0.00

QC Memo

0.00

## Quality Control

180	QC10- Inspect visual per QSI004- ground welds	0.00
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QC10- Inspect visual per QSI004- ground welds

0.00

QC Memo

0.00

## Quality Control

190	Pressure Wash per QSI005 4.3	0.00
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Pressure Wash per QSI005 4.3

0.00

HandFinish Memo

0.00

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 74797****\*74797\***

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Item ID: D119-646-241

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Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 10/06/11 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	Identify as per dwg & Stock Location: _____	0.00							
<b>*260*</b>									
Packaging	Memo	0.00							
Packaging									
270	QC21- Final Inspection - Work Order Release	0.00							
<b>*270*</b>									
QC	Memo	0.00							
Quality Control									

*Restock  
I born!**mf  
12-07-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 74797

**\*74797\***

Parent Item: D119-646-241

**\*D119-646-241\***

Parent Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-190 <b>*D2500-1-190*</b> Ext'n - I' Beam Tube 4"		Manufactured	No			110	Each	27.0000	1	1			
									**	DC 12/05/16			
			<u>Location</u> B74777		<u>Loc Qty</u>		<u>Loc Code</u>		①				
			LG		27								
			66296		27								
D3885-1 <b>*D3885-1*</b> Standard Web		Manufactured	No			140	Each	12.0000	1	1			
									**	DC 12/05/16			
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		①				
			LG		12								
			52421		12								
D3903-1 <b>*D3903-1*</b> Spacer		Manufactured	No			160	Each	15.0000	12	12			
									**				
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			LG001		15								
			47476		7								
			51849		8								
D3681-1 <b>*D3681-1*</b> Spacer		Manufactured	No			160	Each	39.0000	8	8			
									**				
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			LG		39								
			68958		2								
			69893		2								
			71845		35								

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 74797

**\*74797\***

Parent Item: D119-646-241

**\*D119-646-241\***

Parent Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 1.00

Required Qty: 1.00

D2855-3	Manufactured	No	240	Each	7.0000	2	2
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**\*D2855-3\*****\*\***

Cap

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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FP005	7	
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52281	7	
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AN3C5A	Purchased	No	240	Each	1,520.000	4	4
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**\*AN3C5A\*****\*\***

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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FP-A	7	
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115835	7	
--------	---	--

ST350	1513	
-------	------	--

116419	28	
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117343	314	
--------	-----	--

117764	169	
--------	-----	--

117872	2	
--------	---	--

118451	500	
--------	-----	--

119127	500	
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D3904-1	Manufactured	No	240	Each	236.0000	16	16
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**\*D3904-1\*****\*\***

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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ST090	236	
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51875	236	
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D3672-1	Manufactured	No	240	Each	360.0000	4	4
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**\*D3672-1\*****\*\***

Phenolic Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST074	360	
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72229	360	
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*74797\***

Parent Item: D119-646-241

**\*D119-646-241\***

Parent Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 1.00

Required Qty: 1.00

D3849-041 Manufactured No

240 Each

3.0000

1

1

**\*D3849-041\*****\*\***

FWD WEARPLATE ASSY, STD/FLOAR GEAR

LocationLoc QtyLoc Code

FP009

3

53030

3

D3849-043 Manufactured No

240 Each

3.0000

1

1

**\*D3849-043\*****\*\***

AFT WEARPLATE ASSY, STD GEAR

LocationLoc QtyLoc Code

FP009

3

52402

3

AN3C46A Purchased No

240 Each

67.0000

8

8

**\*AN3C46A\*****\*\***

BOLT

LocationLoc QtyLoc Code

ST355

67

118757

17

118758

50

MS21043-3 Purchased No

240 Each

951.0000

8

8

**\*MS21043-3\*****\*\***

Nut

LocationLoc QtyLoc Code

FG

72

103691

72

ST301

879

118077

1

118614

492

118686

386

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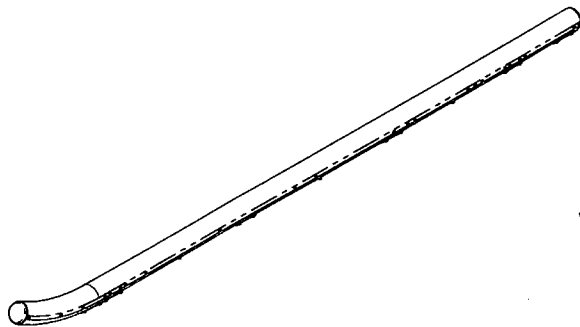
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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NO. 74797

M.L.O

11/10/06

**D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD (SHOWN)**  
**D3887-043 STANDARD SKIDTUBE ASSY WITH WEAPLATE (SIMILAR)**  
**D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)**

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3887-041	STD SKIDTUBE ASSY WITH WEARPAD
2		X		D3887-043	STD SKIDTUBE ASSY WITH WEARPLATE
3			X	D3887-045	STD SKIDTUBE ASSY WITH TRAINING WEARPLATE
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	4	4	4	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	5			D3846-1	GASKET
16	1			D3846-11	GASKET
17	5	5		D3847-1	WEARPAD
18	1	1		D3847-11	AFT WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-047	AFT WEARPLATE ASSY
22			1	D3849-041	FWD TRAINING WEARPLATE ASSY
23			1	D3849-043	AFT WEARPLATE ASSY
24	1	1	1	D3885-1	STANDARD WEB
25	1	1		D3887-11	STANDARD SKIDTUBE
26			1	D3887-13	STANDARD SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
41	30	30		ALS4-1032-130	INSERT
42	34	34	4	AN3C5A	BOLT
43			8	AN3C46A	BOLT
44	34	34		NAS1149C0332R	WASHER (OR AN960C10L)
45			8	MS21043-3	NUT

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-1 WEB  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3887-041 = 32.0 lbs  
D3887-043 = 37.0 lbs  
D3887-045 = 38.1 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) INSERT D3885-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO  $\phi 0.197$  HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8931 TO LOCATE AND DRILL  $\phi 0.297$  HOLES FOR WEARPLATE INSERTS. INSTALL AELS-1032-130 INTO D3887-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/-291.

RELEASED  
07/07/06

B	ALS4-1032-130 WAS AELS-1032-130, ZN C4-1, C5-7, C3-7; ADD DT8931, ZN A6-1; ADD 134-04, ZN C4-8; D2855-3 WAS D2575 (ZN D4-1, C7-2, C2-2, C7-3, C2-3, C7-4, C2-4); AN3C5A WAS AN3C4A (ZN C6-2, C2-2, C6-3, C2-3, C6-4, C2-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3887	SHEET 1 OF 8
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DE APPR.	RF	A119 STD SKIDTUBE ASSY	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

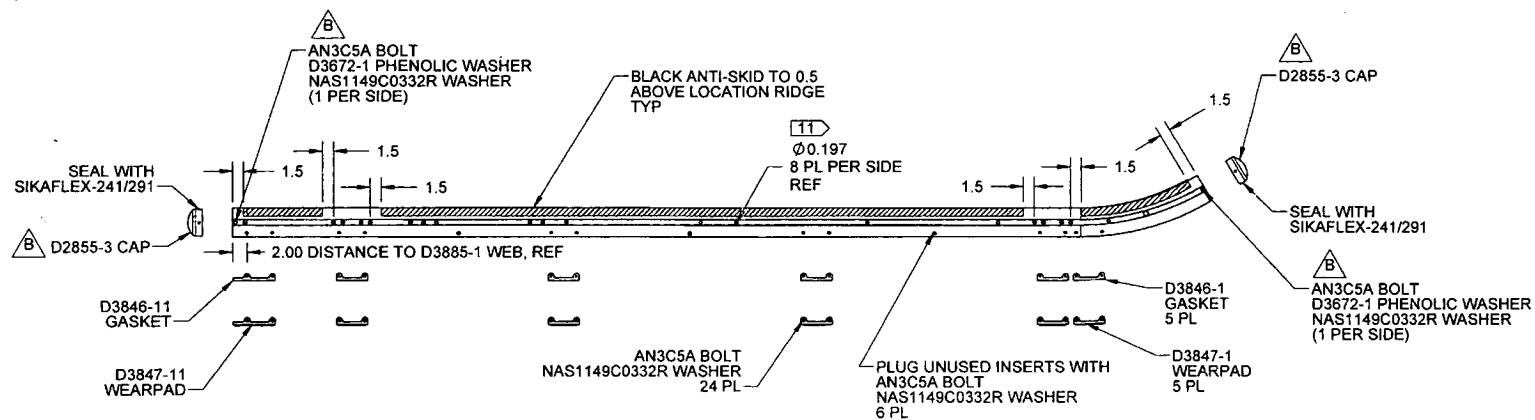
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD**  
(MAKE FROM D3887-11)

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2/17/15

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

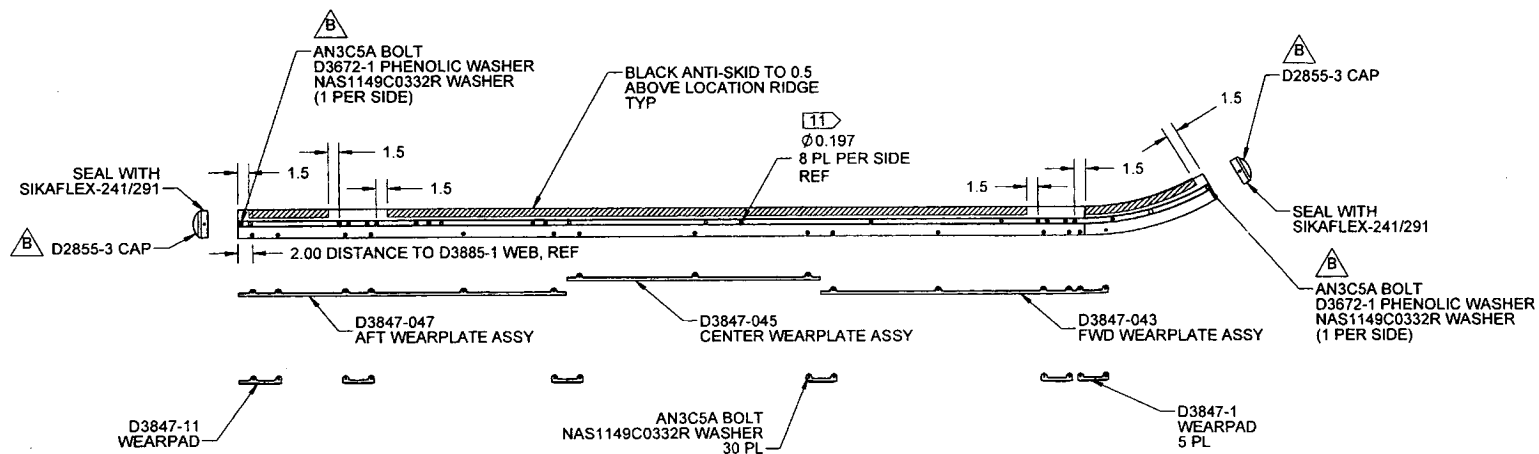
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**D3887-043 STANDARD SKIDTUBE ASSY WITH WEARPLATE**  
(MAKE FROM D3887-11)

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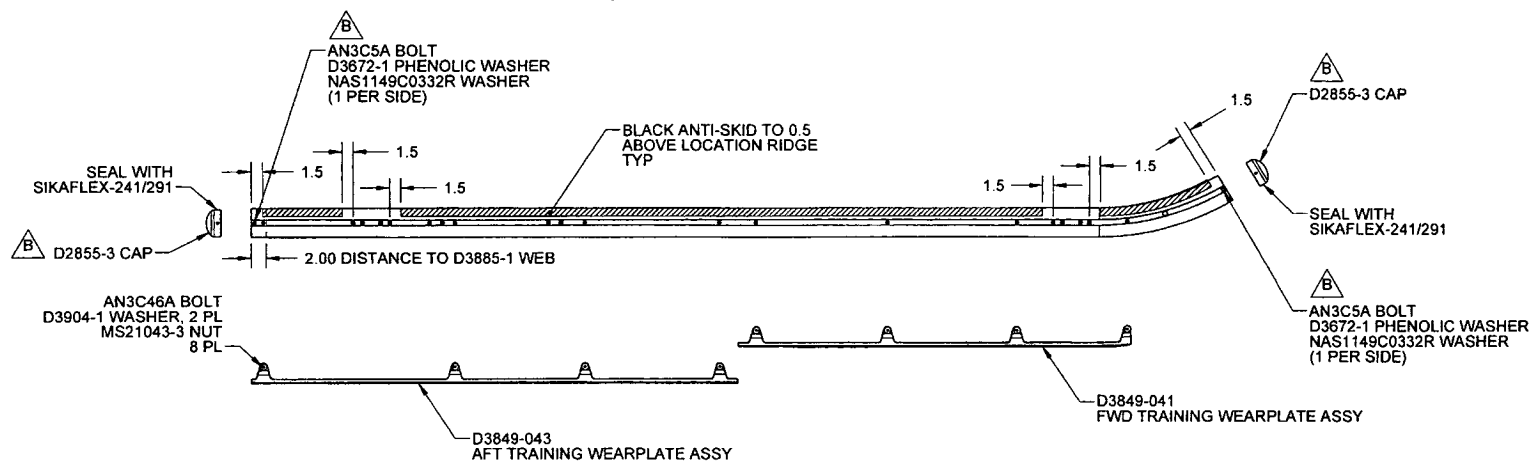
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**D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE**  
(MAKE FROM D3387-13)

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21/07/19

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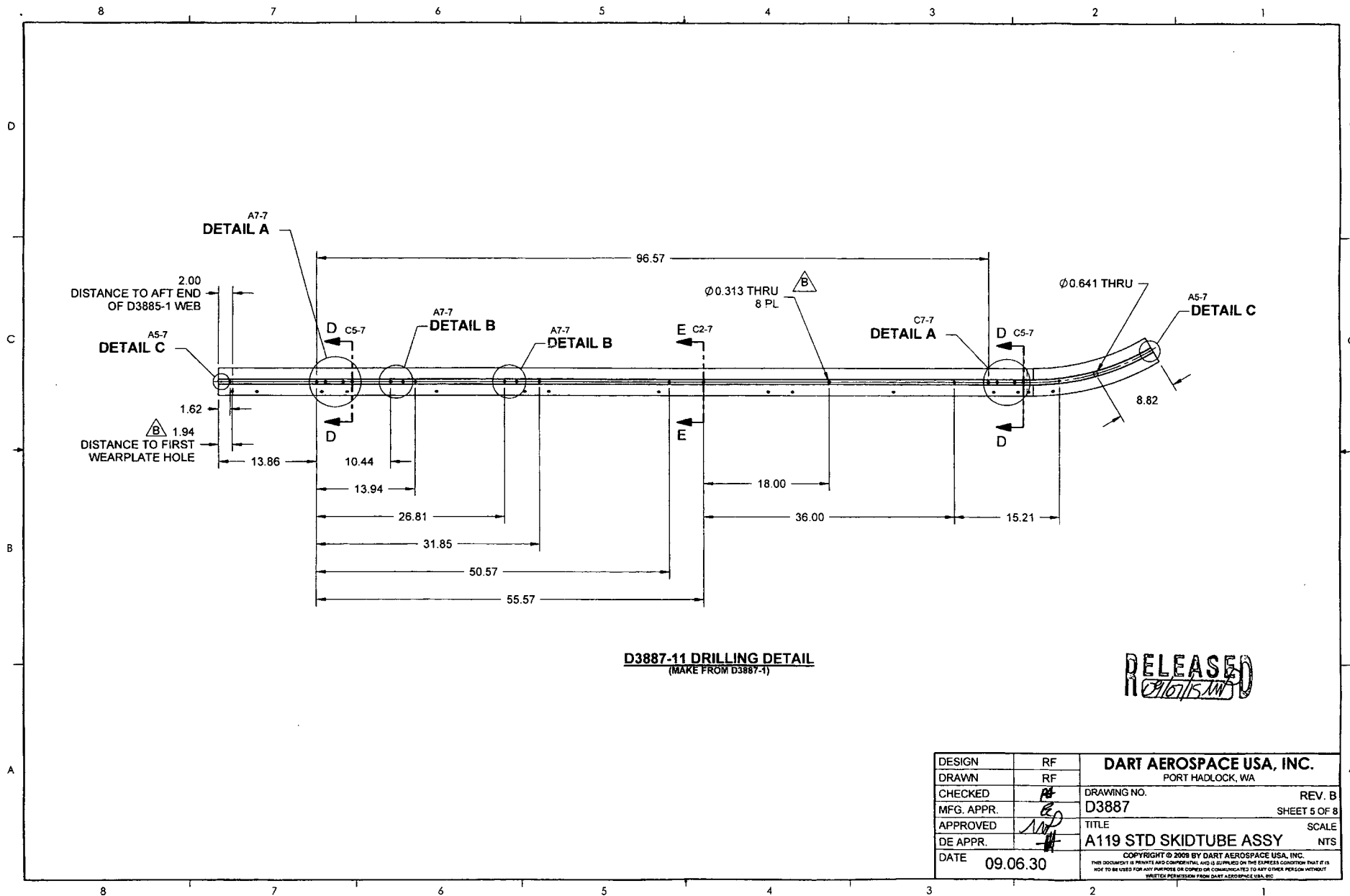
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**D3887-11 DRILLING DETAIL**  
(MAKE FROM D3887-1)

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

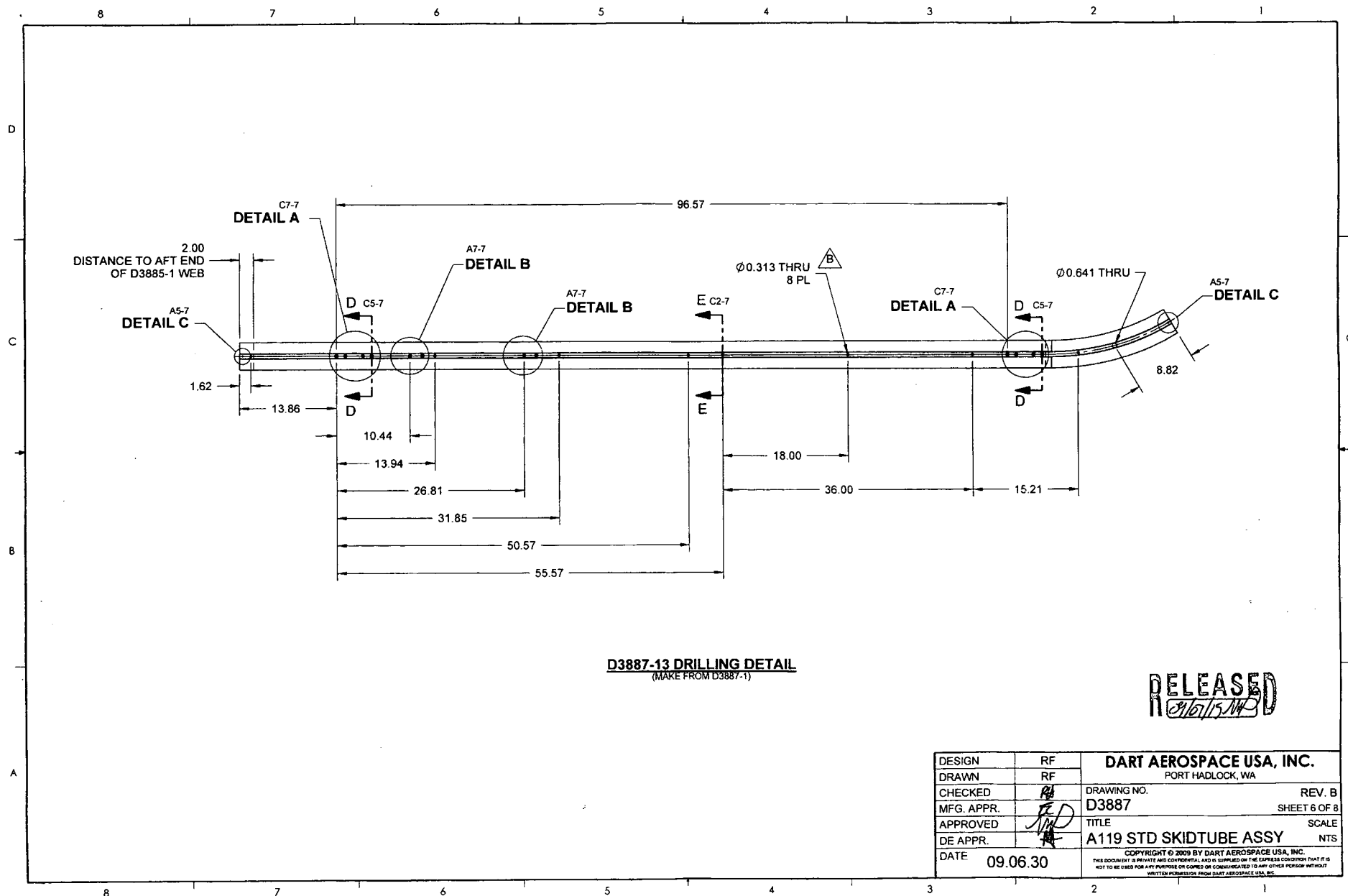
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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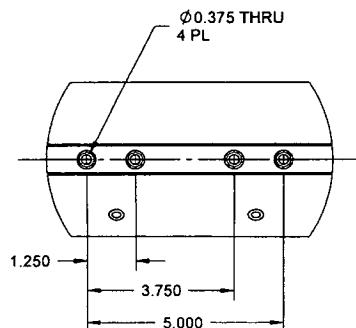
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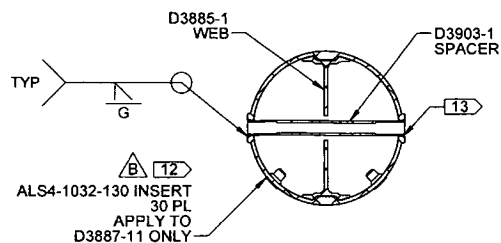
**NOTE:** Date & initial all entries

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**DETAIL A**  
SCALE 4X

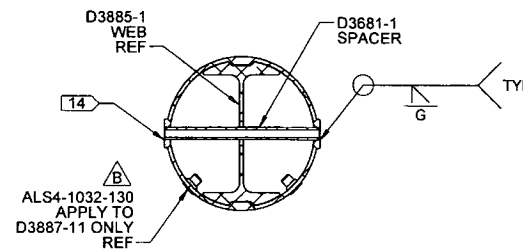
D7-5  
C3-5  
D7-6  
C3-6



**SECTION D-D**  
SCALE 4X

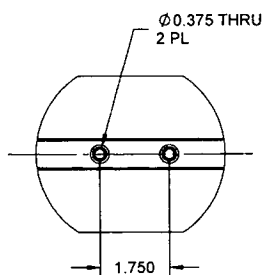
(FOR 12 X Ø0.375 HOLES  
PER SKIDTUBE)

C7-5  
C3-5  
C7-6  
C2-6



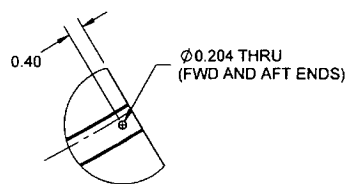
**SECTION E-E**  
SCALE 4X  
(FOR 8 X Ø0.313 HOLES  
PER SKIDTUBE)

C4-5  
C4-6



**DETAIL B**  
SCALE 4X

C6-5  
C6-5  
C6-6  
C6-6



**DETAIL C**  
TYPICAL  
SCALE 4X

C8-5  
C1-5  
C8-6  
C1-6

**NOTES:**

13) AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:

- i) CHAMFER HOLES Ø0.475 x 45°
- ii) INSERT D3903-1 SPACER
- iii) WELD INTO PLACE AND GRIND FLUSH
- iv) C BORE TO 0.313 x 0.75 DEEP
- v) DEBURR HOLES

14) AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.313 HOLES ONLY:

- vi) CHAMFER HOLES Ø0.354 x 45° OR 0.050 DEEP x 45° (BOTH SIDES)
- vii) INSERT D3681-1 SPACER
- viii) WELD INTO PLACE AND GRIND FLUSH
- ix) DEBURR HOLES

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09/07/2009

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MFG. APPR.	RF	SHEET 7 OF 8	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>A119 STD SKIDTUBE ASSY</b>	
DATE	09.06.30	NTS	

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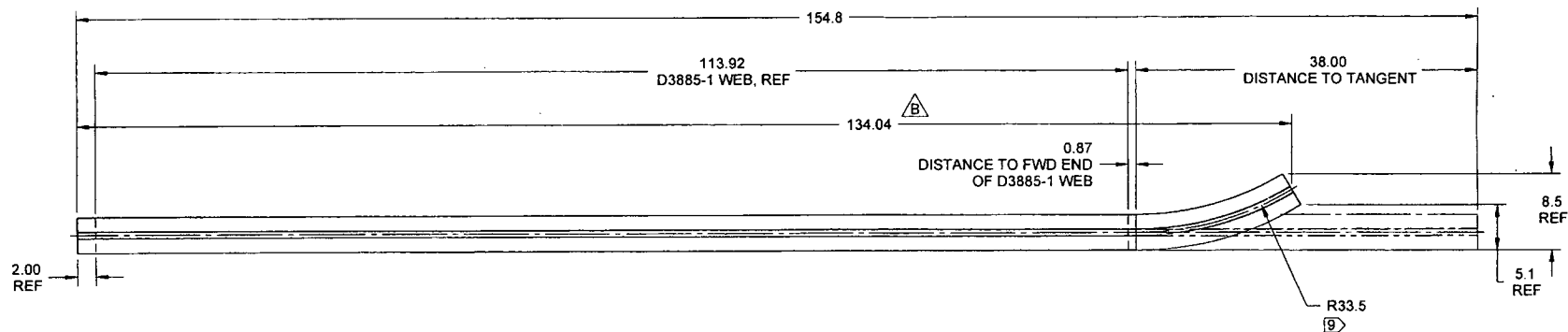
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**D3887-1 BEND DETAIL**  
(MAKE FROM D2800-1-190 EXTRUSION)

**RELEASED**  
10/15/15

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MFG. APPR.	RF	D3887	SHEET 8 OF 8
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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